

Work Order ID 161333

Thursday, May 11, 2017 10:11:18 AM

Airbus

161333

Ship JUNE 1

Page 1

Item ID: D350-615-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GHW Modification, Fits LH or RH
 Start Date: 5/15/2017 Start Qty: 70.00 ***70*** Cust Item ID:
 Required Date: 5/26/2017 Req'd Qty: 70.00 ***70*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 11 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003								
110		0.00							
110									
Small Fab	Memo	1.91							
Small Fab	Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts***								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	1.40							
Quality Control									

DAS 21 9-89

MAY 16 2017

Back

70

DAS 21 9-89

MAY 16 2017

70

MAY 29 2017

DAS 19 9-89

70

MAY 30 2017

DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 2.10				70	DAS 28 9-89		MAY 3 1 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023 Fg	0.00 0.00				70	DAS 28 9-89		MAY 3 1 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 7.00					DAS 21 9-89		MAY 3 1 2017

DAS
21
9-89

MAY 3 1 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
82 83 84								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Page 1

Work Order ID: 161333

161333

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 5/15/2017

Required Date: 5/26/2017

Start Qty: 70.00

Required Qty: 70.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041 *D2282-041* T Assembly		Manufactured	No		161266 6160640	110 8	Each	2.0000	1	70		MAY 29 2017	DAS 19 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	160639		2	20					
					138067		2	20					
D2282-043 *D2282-043* Saddle Assembly		Manufactured	No		154047	110	Each	5.0000	1	70		MAY 29 2017	DAS 19 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	161275		5	20					
					151899		5	20					
5/16-18-015C *5/16-18-015C* SS Bolt 5/16-181.5"		Purchased	No		160579	110	Each	264.0000	3	210			DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST583			264						
					m137100		64						
					m137324		200						

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Page 2

Work Order ID: 161333

161333

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 5/15/2017

Required Date: 5/26/2017

Start Qty: 70.00

Required Qty: 70.00

D3015-3 Manufactured No

110 Each 262.0000 3 210

D3015-3

Locknut

**

DAE
9-89

MAY 16 2017

Location Loc Qty Loc Code

FG 18

95758 8

96151 10

ST015 244

158471 244

5/16WC Purchased No

110 Each 1,039.000 12 840

5/16WC

Washer

**

DAS
9-89

MAY 16 2017

Location Loc Qty Loc Code

ST583 1000

m137324 1000

WA001 39

m136525 39

7/16-14-050C Purchased No

110 Each 80.0000 1 70

7/16-14-050C

SS Bolt 7/16 5" Long

**

DAS
9-89

MAY 16 2017

Location Loc Qty Loc Code

ST584 80

m136525 10

m137324 70

D3015-5 Manufactured No

110 Each 110.0000 1 70

D3015-5

SS Nylock Nut 7/16

**

DAS
9-89

MAY 16 2017

Location Loc Qty Loc Code

ST015 110

154892 10

160671 100

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Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 3

Work Order ID: 161333

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Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 5/15/2017

Required Date: 5/26/2017

Start Qty: 70.00

Required Qty: 70.00

7/16WC

Purchased

No

110

Each

31.0000

2

140

7/16WC

Washer, SS Flat 7/16

137547x183

MAY 16 2017

Location

Loc Qty

Loc Code

ST584

31

m136279

31

DAS
6
9-89

35

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 161333

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Airbus
161333*Ship JUNE 1*

Page 1

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 5/15/2017 Start Qty: 70.00

70

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 70.00

70

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan:

Date: **MAY 11 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-615-041

B

100

Document Control

de
MAY 16 2017
0.00***100***

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHIG003

110

0.00

110

Small Fab

Small Fab

Memo

1.91

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

1.40